

Work Order ID 54955

January 5, 2010 10:44:16 AM

Page 1

Item ID: D350-636-012

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube RH

Start Date: 05/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 18/01/2010 Req Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-05 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

8 10/02/01

JG MF 10/01/30

54955

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Custom:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

10-Grind welds flush as per Dwg D2750

M
10/1/14

M112860 BE 10/01/14

10/1/14

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- scribe batch #.

4 10/1/13

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

⇒ 10/01/14

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 10/01/14



Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 10/1/14

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev. Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP 10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

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Run Start



Approvals:

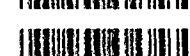
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M112395
exp. date: 12/1/30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M112860

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places perside) as per dwg D2750

M10/11/15

M10/11/15

AE 10/1/18

AWM 10-1-19

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11 - At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 10/01/18

12-Deburr holes

170

QC10- Inspect visual per QS1004- ground welds

0.00



⇒ Sub 120

QC

Memo

0.00

Ⓢ

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



⇒ Sub 120

QC

Memo

0.00

Ⓢ

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

⇒ M 10-01-20

(XL) 8

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M113170

Memo

0.00

⇒ M 10-01-20

(XL) 8

Powder Coating

START TIME: 11:30AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 12:00PM

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 10-01-25

(D)

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

BR 10-01-25.

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: _____

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

BATCH: 112343

EXP DATE: 10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 104223

5-Coat all exposed fasteners with "LPS Procyon"
batch: 104251

BR 10-01-26..

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



⇒ 8/10/27

QC

Memo

0.00

(40)

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

10-1-29

SL

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



⇒ 8/10/26/1

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00



Packaging

Rev H

10-2-8

SP

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

280

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/02/09

MF 10-2-9

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:21 AM

Page 1

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Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	6,691.000	38.0000			

Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6691	
107441	16	
110768 ✓	6675	

38 ✓ 10-α-26

AN3C5A	Purchased	No

230	Each	609.0000	34.0000

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 113044	609	
111424	8	
111707	69	
112314	1	
113121	231	
113149	300	

34.15 ✓ 10-α-26

AN3C6A	Purchased	No

230	Each	828.0000	4.0000

BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	828	
111982 ✓	828	

4 ✓ 10-α-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A		Purchased	No			230	Each	148.0000	4.0000			
BOLT												

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	146	
110105	4	
110155	14	
110665	1	
111605 ✓	50	
111649	50	
112720	9	
113121 ✓	18	

2 BX 10-01-26
2 BX 10-01-26

AN8C35A

Purchased

No

230

Each

137.0000

1.0000



BOLT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	137	
102180	1	
106896	1	
110105	48	
110847 ✓	87	

1 BX 10-01-26

January 5, 2010 10:44:21 AM

Shop Packet Print

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	East Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L 		Purchased	No			230	Each	416.0000	38.0000			
washer												

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

NAS1149C0332R FG 113298 100

103585 100

Main Warehouse

ST 316

112116 156

112612 160

88. bkr 10-a-26

AN960C816L

Purchased

No

230

Each

240.0000

1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 240

104093 2

107520 4

110139 29

110584 100

111424 ✓ 105

1 bkr 10-a-26

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D2745		Manufactured	No			230	Each	346.0000	8.0000			

Bushing

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	59	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
43754	2	
44893	33	
45556	1	
Main Warehouse		
ST46	287	
51537✓	70	
51910✓	36	
52311	181	

4 10-a-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:21 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3488-042 		Manufactured	No			230	Each	16.0000	1.0000			
Blade Fitting Assembly, RH												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
29043	1	
52666 ✓	15	

1/10-01-26

D3492-041



Manufactured No

230 Each 76.0000 8.0000

Plug Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	76	
51584 ✓	76	

8/10-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:21 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-043		Manufactured	No			230	Each	143.0000	8.0000			

Plug Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	123	
54682 ✓	123	
Main Warehouse		
ST	20	
52309	20	

8. BL 10-01-26

D3535-25

Manufactured No



Wearshoe

230 Each 15.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	7	
51927 ✓	7	
Main Warehouse		
ST	8	
52589	8	

1 BL 10-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:21 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25		Manufactured	No			230	Each	40.0000	1.0000			

Gasket

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP10	35	
51607 ✓	9	
54479	26	
Main Warehouse		
ST	5	
45569	1	
47011	2	
47526	2	

1 pk 10-01-26

D3537-1

Manufactured No

230

Each

141.0000

3.0000



Wearpad

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	139	
51678 ✓	34	
51679	105	

3 pk 10-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3631-1

Manufactured

No

230

Each

442.0000

8.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

442

52693 ✓

142

54388

300

8 BX 10-01-26

D3672-1

Manufactured

No

230

Each

1,744.0000

4.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1244

39275

19

42329

5

47628 ✓

220

52505

1000

4. BX 10-01-26

Main Warehouse

ST117

500

51674

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3791-1		Manufactured	No			230	Each	11.0000	1.0000			
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Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

51610 ✓

7

Main Warehouse

ST

4

51909

4

D3793-1		Manufactured	No			230	Each	19.0000	1.0000			
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Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

19

40551

1

51597 ✓

16

51906

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3		Manufactured	No			230	Each	16.0000	1.0000			
Wearshoe												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	16	
51592 ✓	12	
51903	4	

1 Bl 10-a-26.

D3794-1		Manufactured	No			230	Each	15.0000	1.0000			
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	12	
51928 ✓	12	
Main Warehouse		
ST	3	
46530	1	
47212	2	

1 Bl 10-a-26.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

January 5, 2010 10:44:22 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3		Manufactured	No		230	Each	21.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	18	
51598 ✓	6	
51907	12	
Main Warehouse		
ST	3	
46531	2	
47440	1	

1 Bk 10-01-06

MS21043-6

Purchased

No

230

Each

1,000.000 4.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1000	
111424	8	
112314 ✓	992	

4. Bk 10-01-06

January 5, 2010 10:44:22 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955

Parent Item: D350-636-012

Parent Item Name: Skidtube RH


Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			230	Each	53.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	53	
110584	5	
111424	2	
112492	6	
113149 ✓	40	

NAS1611-010

Purchased

No

230

Each

330.0000

8.0000

O-RING

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
110715	44	
110915	286	

1 BL 10-01-26

PTD.

W/O: 54955		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-01-26	230.	CHANGE FOR 2594 B. O'RIWO P. 52562	BR	10-01-26	8.		6 10/01/27

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955

Parent Item: D350-636-012

Parent Item Name: Skidtube RH


Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-013 		Purchased		No		230	Each	74.0000	8.0000			
O-RING												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST 11374B	74	
106513	11	
111424	20	
111758✓	43	

AN8C21A

Purchased

No

250

Each

148.0000

2.0000

BOLT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	148	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
112720	38	
113558	50	

3 Bk 10-01-26

5 Bk 10-01-26

[Signature]

M/12720

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955

Parent Item: D350-636-012

Parent Item Name: Skidtube RH


Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010


Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L  WASHER		Purchased	No			250	Each	240.0000	2.0000		10-1-29	sl

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	240	
104093	2	
107520	4	
110139	29	
110584	100	
111424	105	

D2741  Blade, 350 Skidtube		Manufactured	No			250	Each	45.0000	1.0000		10-1-29	sl
---	--	--------------	----	--	--	-----	------	---------	--------	--	---------	----

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	45	
45320	1	
47113	4	
51931	40	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3493-1 Manufactured No



Washer

250 Each 55.0000 2.0000



10-1-29 ✓

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

55

44902

2

47710

53

D3532-1 Manufactured No



Spacer

250 Each 80.0000 2.0000



2
10-1-29 ✓

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

80

44904

2

52321

78

D3672-13 Purchased No



Phenolic Washer

250 Each 948.0000 2.0000



2
10-1-29 ✓

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

948

54363

948

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955

Parent Item: D350-636-012

Parent Item Name: Skidtube RH


Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8		Purchased	No			250	Each	53.0000	2.0000			
												
NUT												

10-1-29 sf

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	53	
110584	5	
111424	2	
112492	6	
113149	40	

D2600-3-BENT
Extrusion Bent

	Manufactured	No				110	Each	16.0000	1.0000			
												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	5	
50675	5	
Main Warehouse		
ST	11	
43495	1	
47133	1	
52346	9	

12/1/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744		Manufactured	No			110	Each	60.0000	1.0000			
												
Cap												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	60	
44892	1	
47488	23	
51922	36	

_____ 1 12/1/14

D2739		Manufactured	No			160	Each	5.0000	1.0000			
												
350 I Beam												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
47124	1	
53900	4	

_____ 1 10/1/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2743		Manufactured	No			160	Each	299.0000	8.0000			

Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 94

50281 50

51913 44

Main Warehouse

ST 205

44891 2

45555 17

48275 1

52310 185

8 EC 12/01/18

D3490-3

Manufactured No

160

Each

37.0000

4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 37

45560 1

48276 31

51930 5

4 EC 12/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:44:22 AM

Work Order ID: 54955



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	84.0000	4.0000			

Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	84	
45338	2	
47657	22	
48277	20	
51932	40	

4 2E 10/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2738	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3538-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D5791-1	WEARPLATE
1	1	1	1	D5793-1	WEARSHOE
1	1	1	1	D5793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C616L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21063C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2738 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PRINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 25.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 1" SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 1) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-8" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCOYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 2) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 3) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER
NO. 54955
BT 10-1-05

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6-7-14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3538-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (6 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3531-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C616; REMOVE QTY (2) MS21063C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/E157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	05.11.18
B	CHANGE MS24694-S253 TO AN8-16A	CP	06.09.21
A	NEW ISSUE	CS	06.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC. PORT HADLOCK, VA	
DRAWN	RL		
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND IS SUBJECT TO THE DART AEROSPACE USA, INC. POLICY THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	

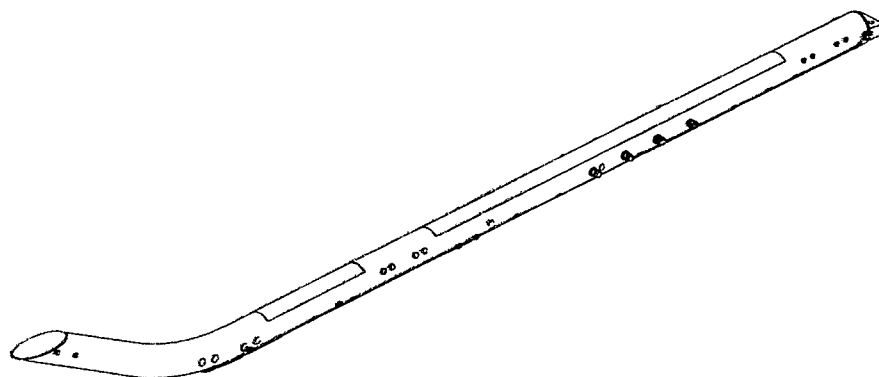
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

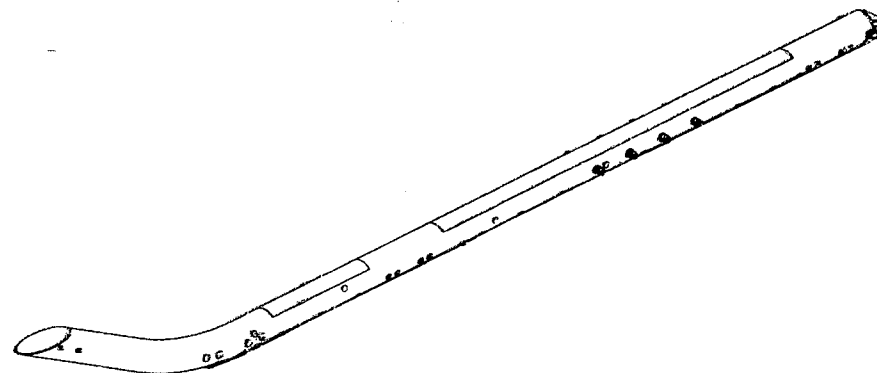
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DRAWN	<i>AM</i>	
CHECKED	<i>RA</i>	DRAWING NO. D2750 REV. 5
MFG. APPR.	<i>RA</i>	SHEET 2 OF 11
APPROVED	<i>RA</i>	TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.	<i>RA</i>	
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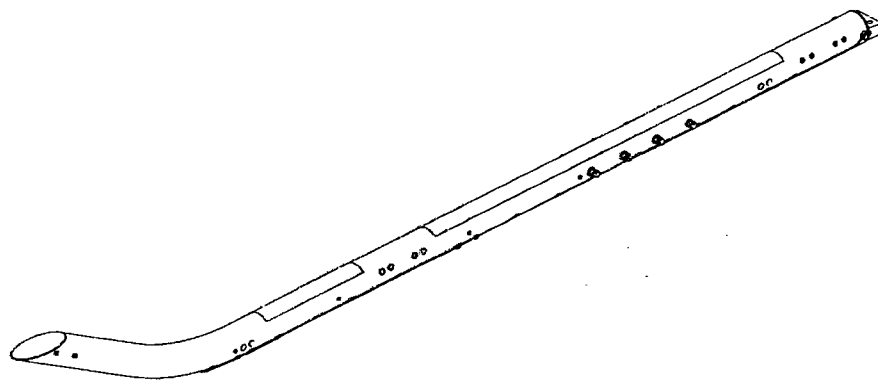
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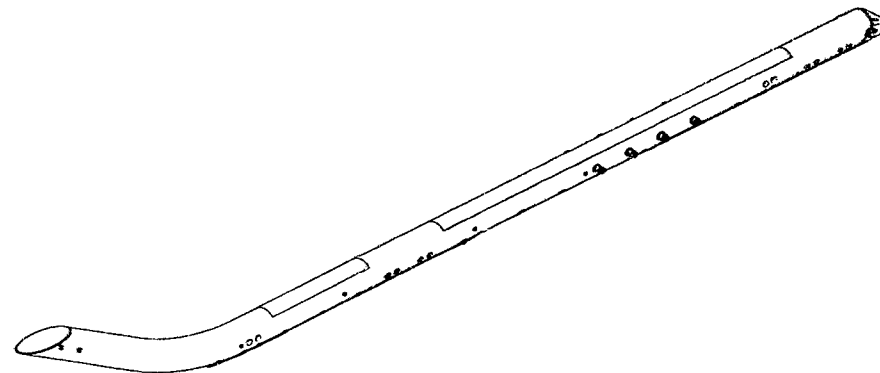
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NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/100

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DRAWN	PD	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
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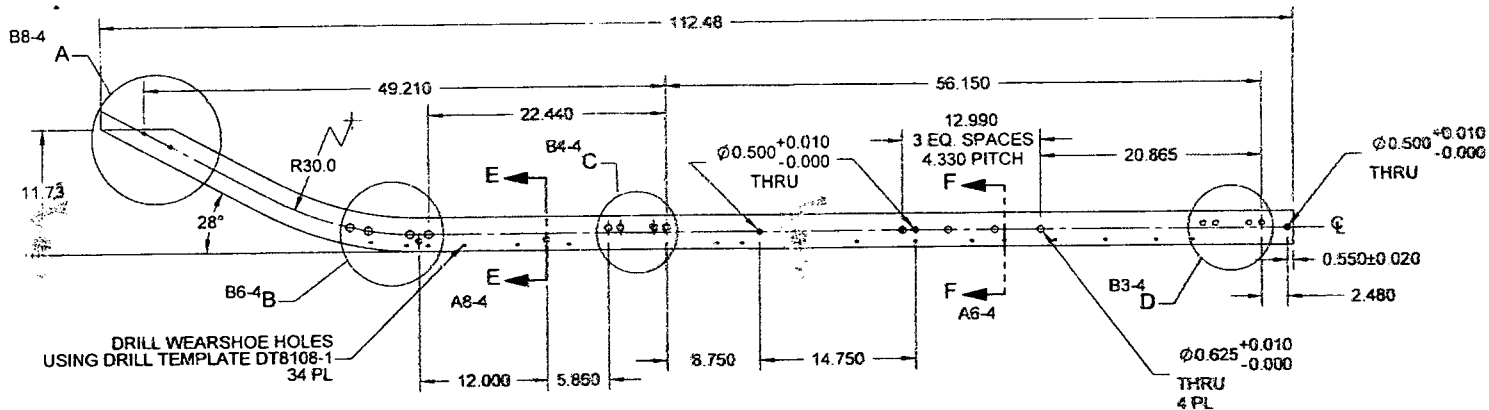
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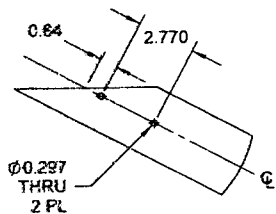
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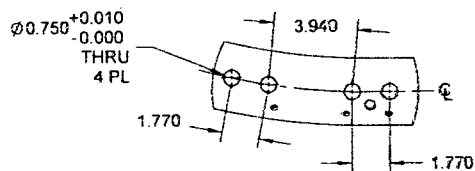
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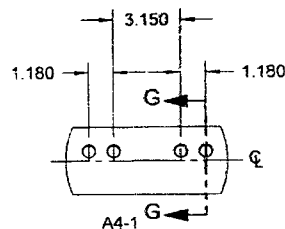
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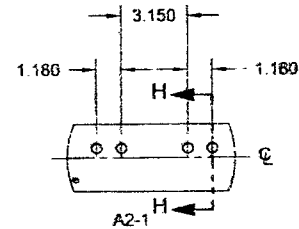
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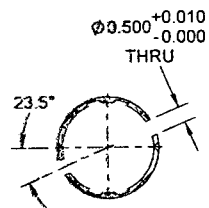
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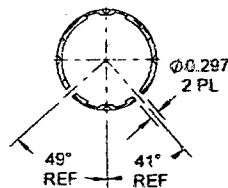
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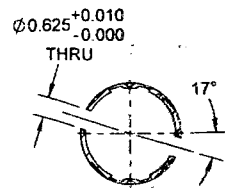
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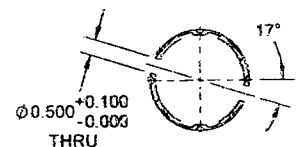
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	W/54955	DART AEROSPACE USA, INC.	REV. F
DRAWN	PS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	SHEET 4 OF 11
MFG. APPR.		TITLE	SCALE
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DE APPR.			
DATE	08.07.16		

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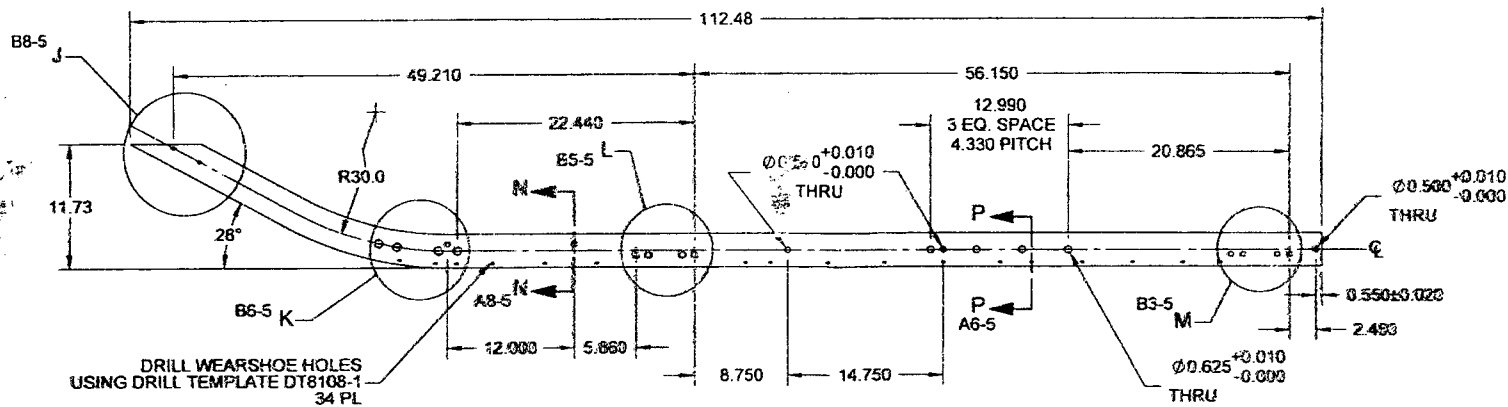
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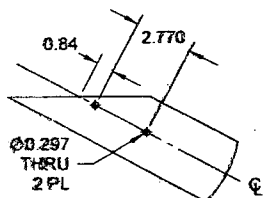
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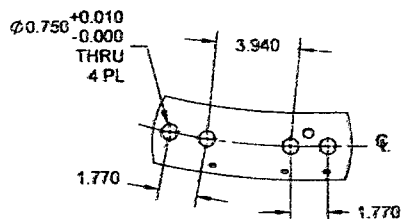
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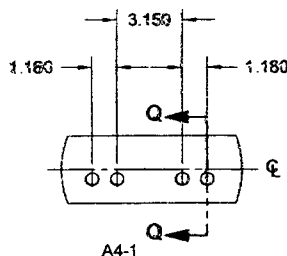
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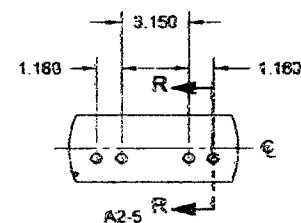
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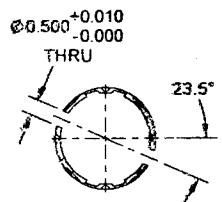
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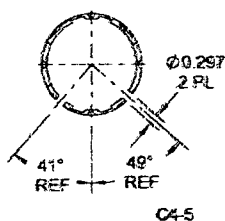
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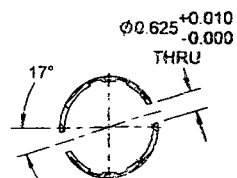
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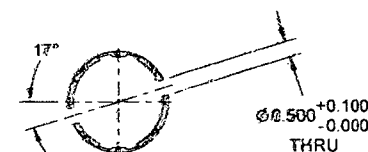
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN	PORT	BART AEROSPACE USA, INC.	
DRAWN	PORT	PORT HADLOCK, VA	
CHECKED	PORT	DRAWING NO.	REV. F
MFG. APPR.	PORT	D2750	SHEET 5 OF 11
APPROVED	PORT	TITLE	SCALE
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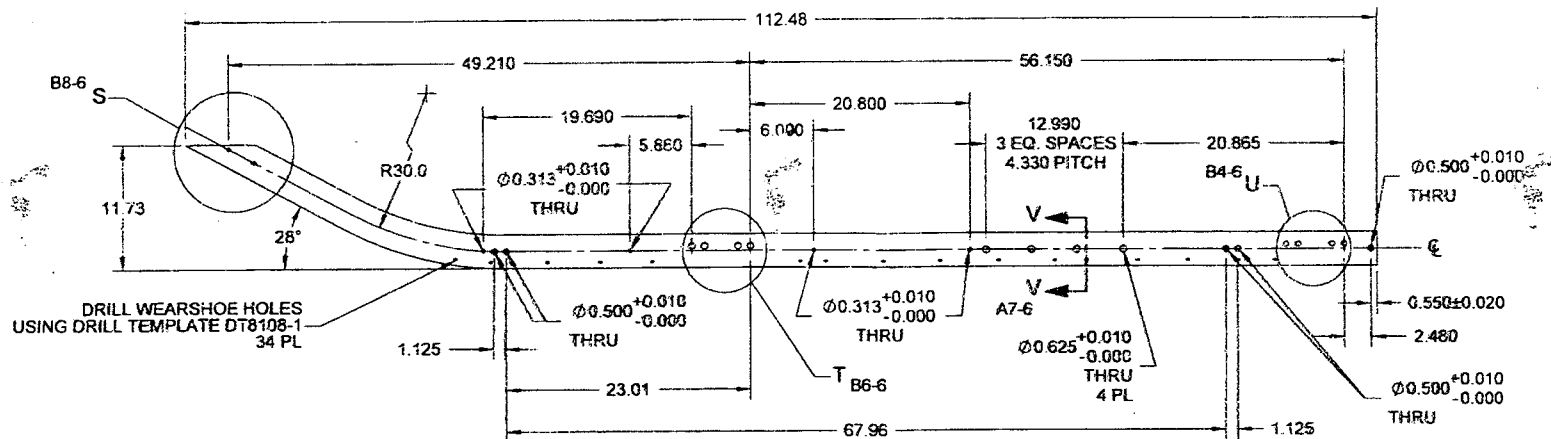
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

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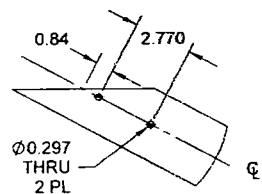
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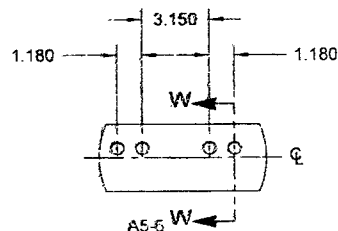
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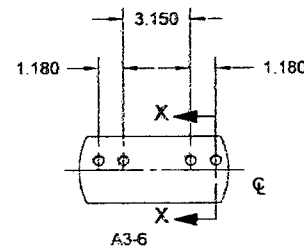
D2750-3 LH SKIDTUBE



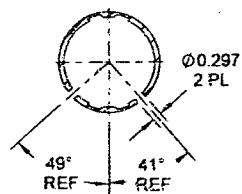
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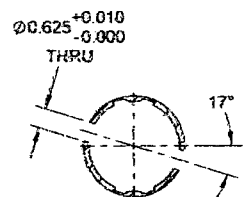
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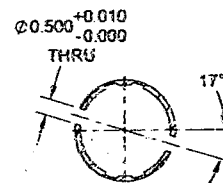
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SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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CHECKED	PG	DRAWING NO. D2750	REV. F
MFG. APPR.	PG	SHEET 6 OF 11	
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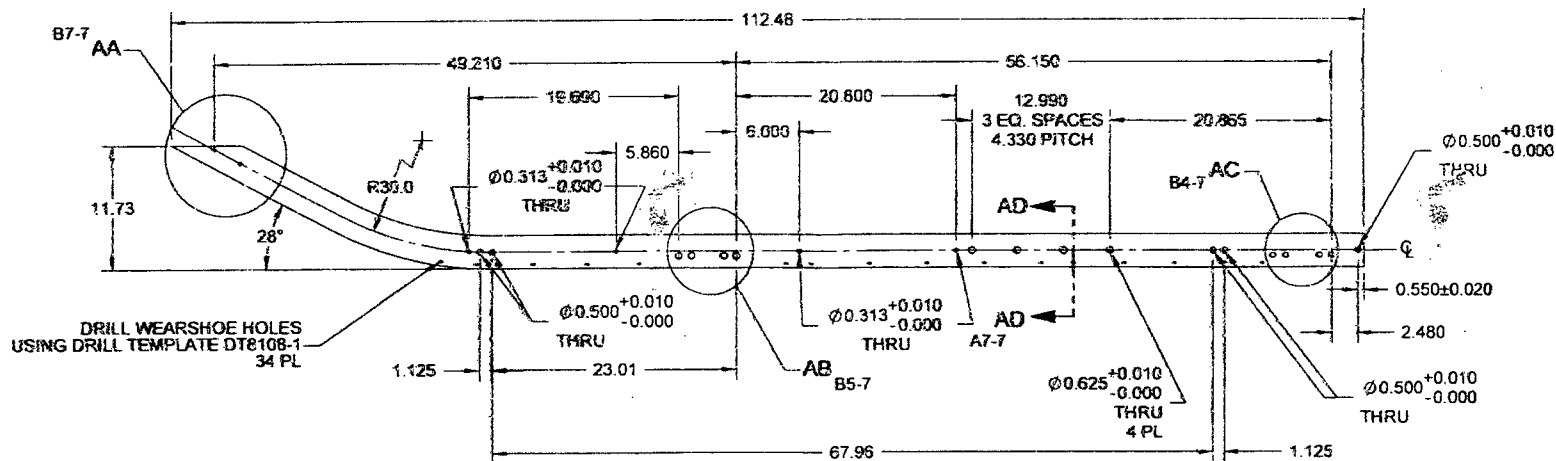
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng*/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

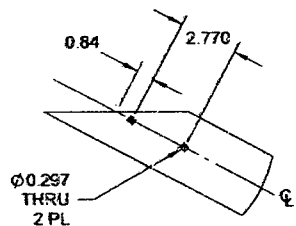
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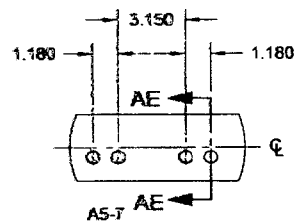
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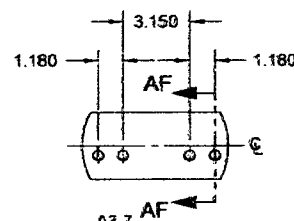
D2750-4 RH SKIDTUBE



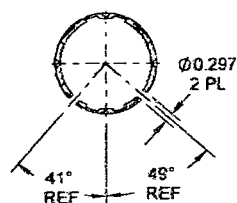
DETAIL AA
SCALE 2X



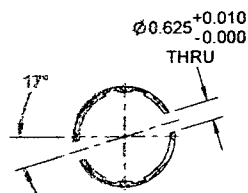
DETAIL AB
SCALE 2X



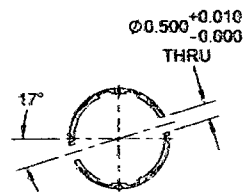
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED
06-22-19

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA.	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W10 54955

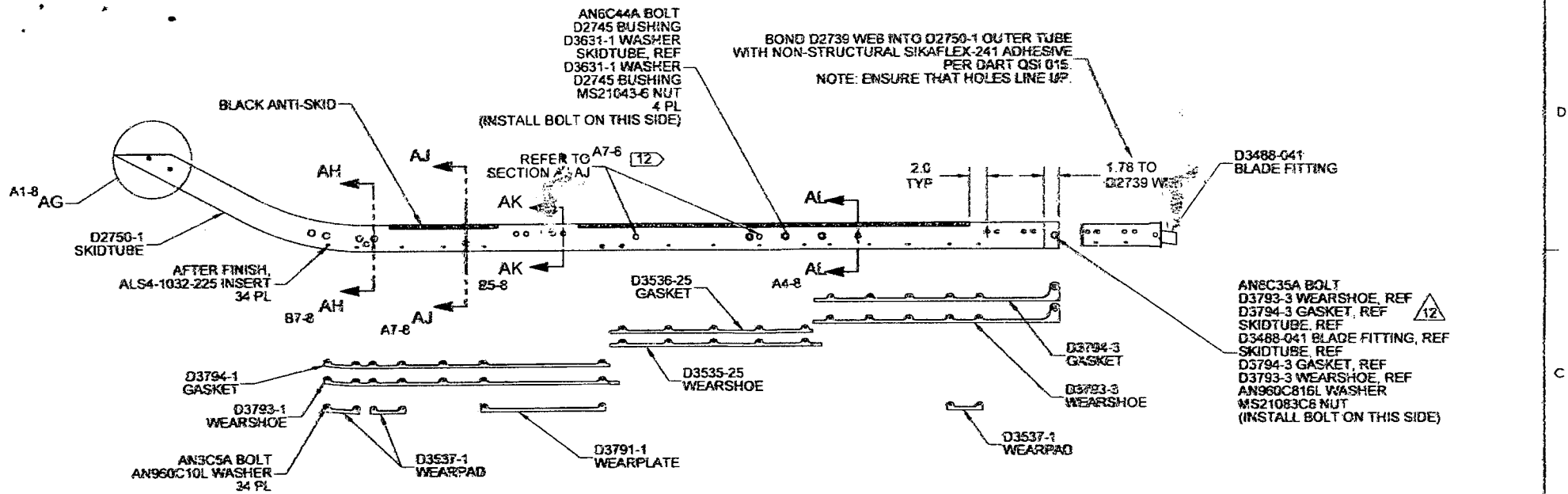
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

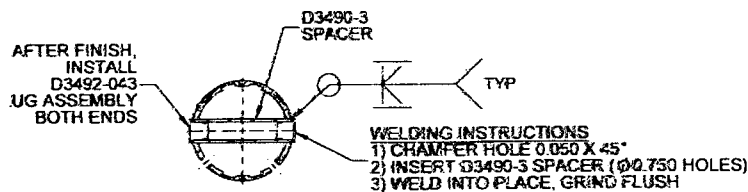
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

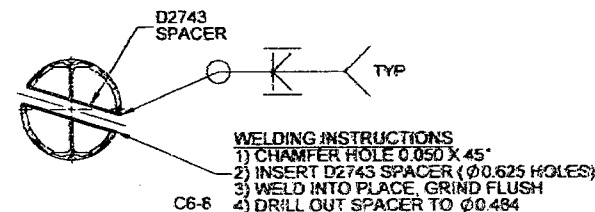
NOTE: Date & initial all entries



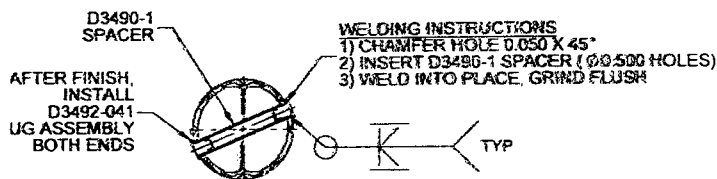
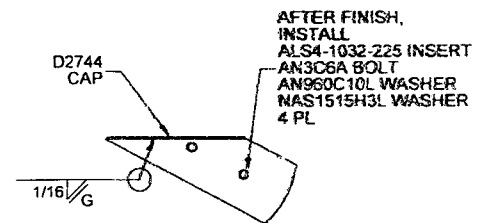
D2750-041 350 SKIDTUBE ASSEMBLY, LH



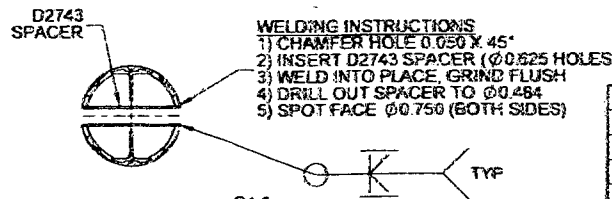
SECTION AH-AH
SCALE 3X, 4 PL



SECTION AK-AK
SCALE 3X, 4 PL



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DETAIL AG D8-8
SCALE 2X
RELEASED
6-27-10

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 8 OF 2X
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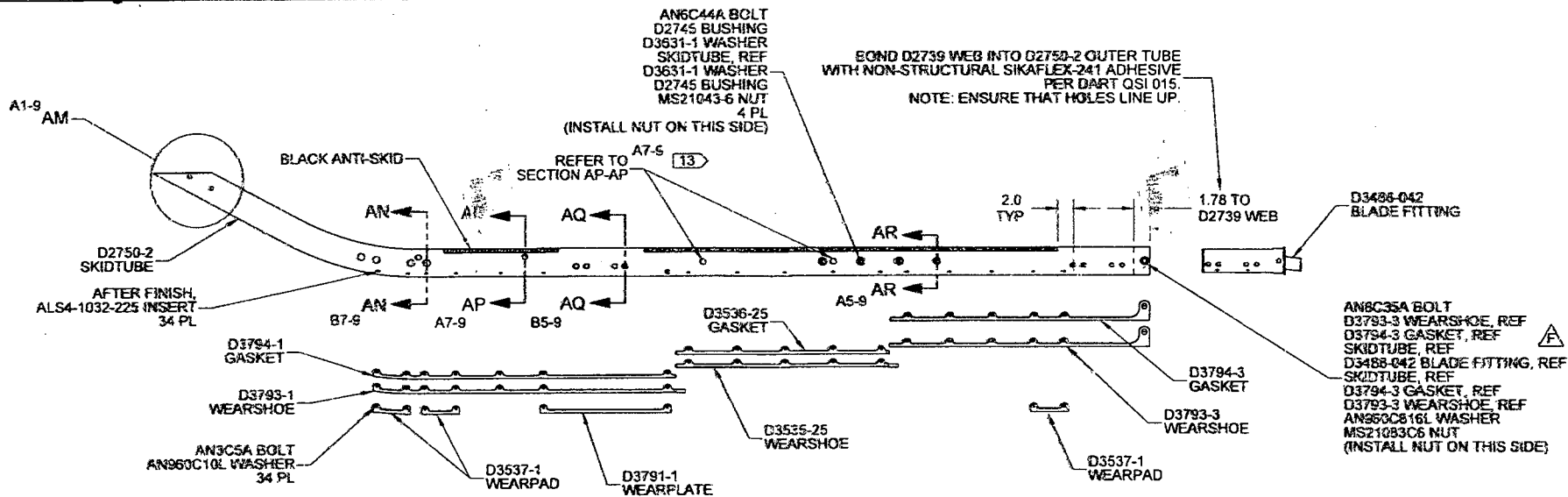
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

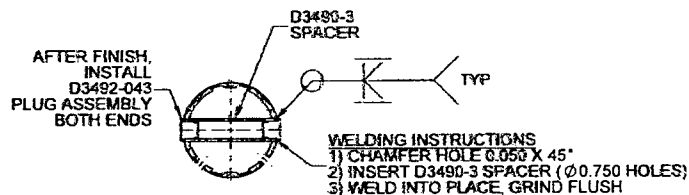
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

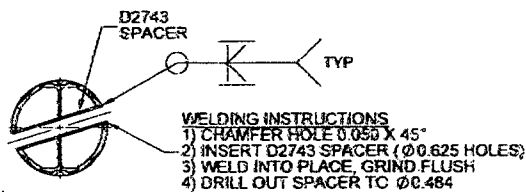
NOTE: Date & initial all entries



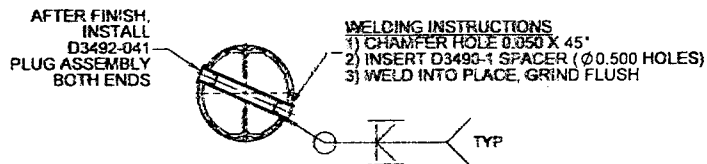
D2750-042 350 SKIDTUBE ASSEMBLY, RH



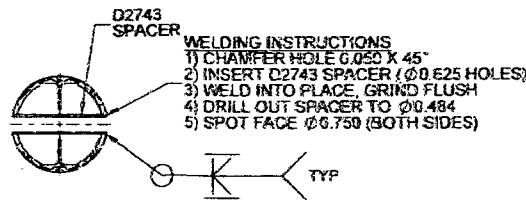
SECTION AN-AN
SCALE 3X, 4 PL



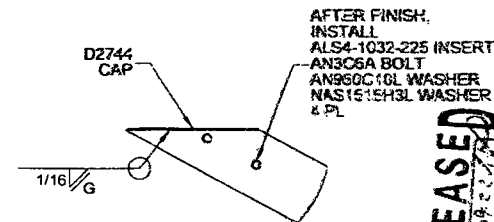
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

DESIGN	W/0 54955	DART AEROSPACE USA, INC.	
DRAWN	W/0 54955	PORT HADLOCK, WA	
CHECKED	W/0 54955	DRAWING NO.	REV. F
MFG. APPR.	W/0 54955	D2750	SHEET 9 OF 11
APPROVED	W/0 54955	TITLE	SCALE
DE APPR.	W/0 54955	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	

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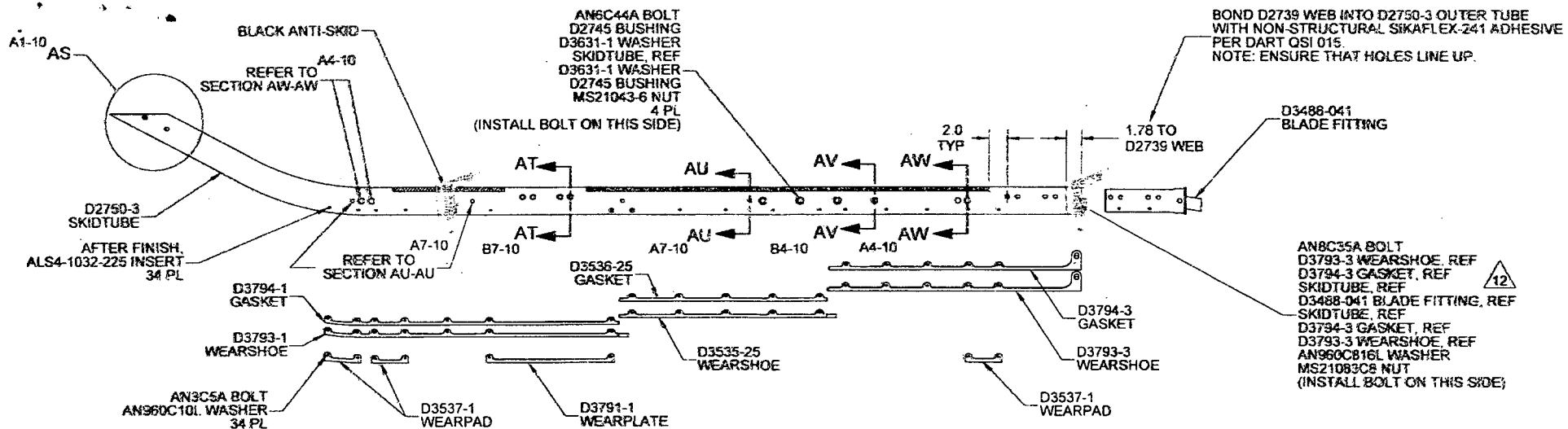
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng? Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

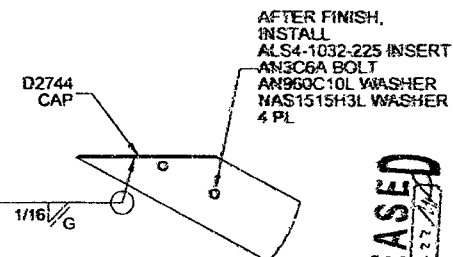
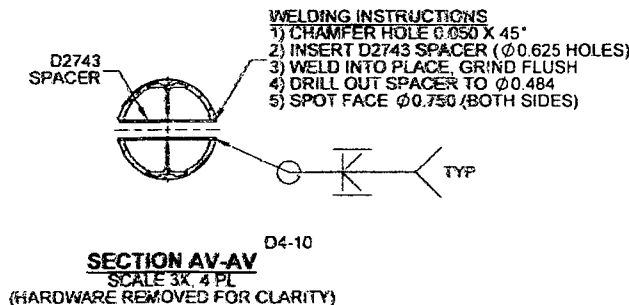
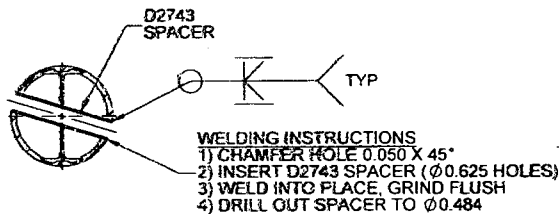
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

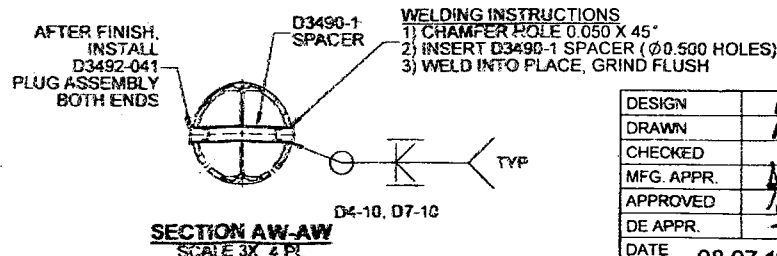
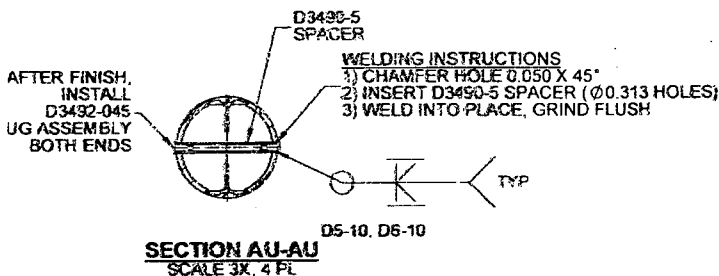
NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH



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CHECKED	W/10 54955	DRAWING NO. D2750
MFG. APPR.	W/10 54955	REV. F
APPROVED	W/10 54955	SHEET 10 OF 11
DE APPR.	W/10 54955	TITLE
DATE	08.07.16	350 SKIDTUBE ASSEMBLY
		NTS

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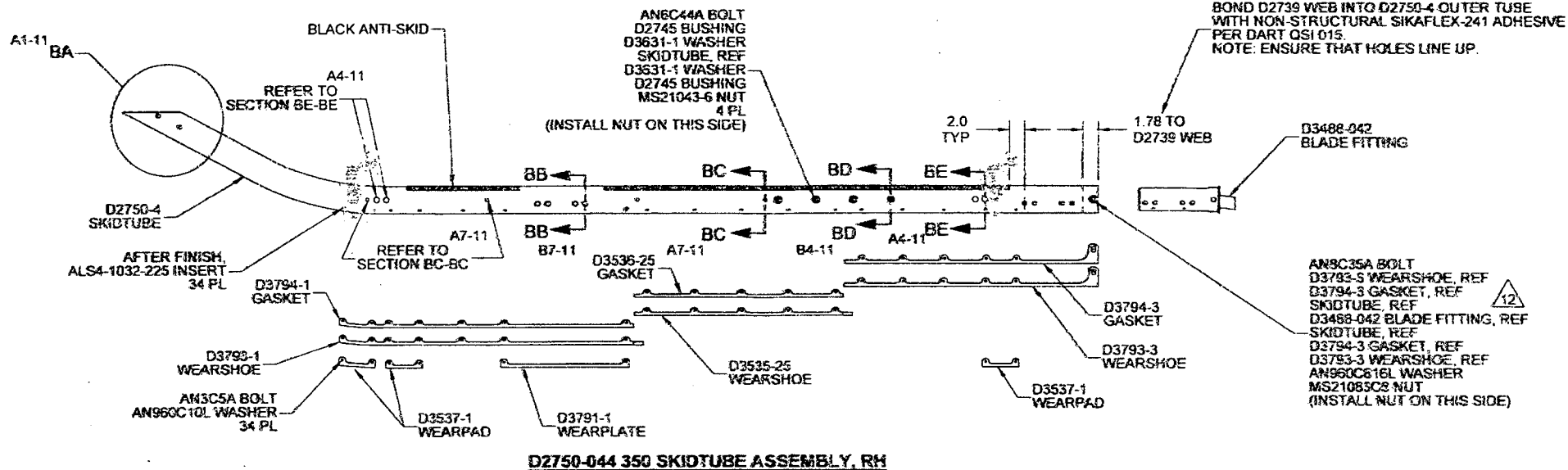
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

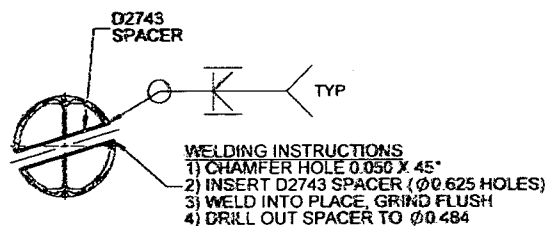
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

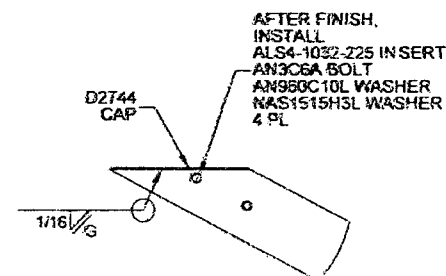
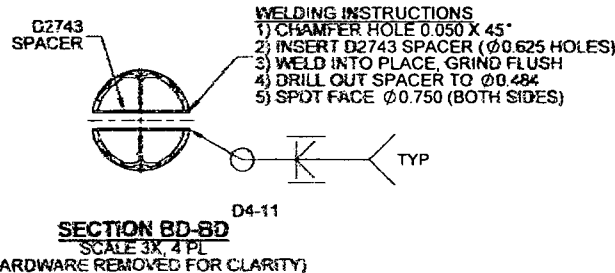
NOTE: Date & initial all entries



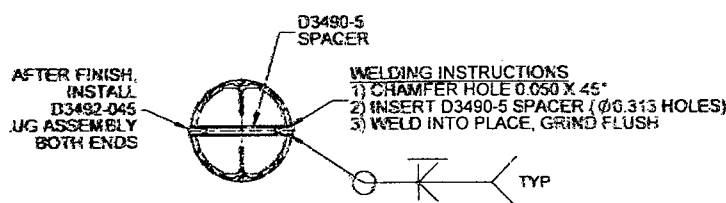
RELEASED
06-07-22 1/11



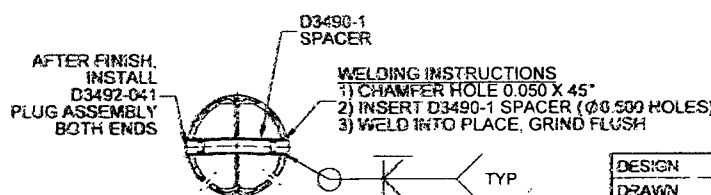
SECTION BB-BB
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

W/054955

DESIGN	RE	DART AEROSPACE USA, INC.	
DRAWN	RE	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 222

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54986
Part number: D350-636 012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10-01-11

Welder Barclay Elliott Date of Test Coupon 10-04-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld